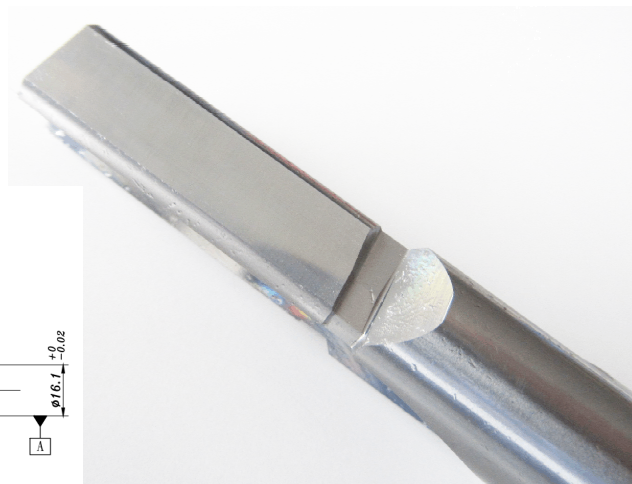
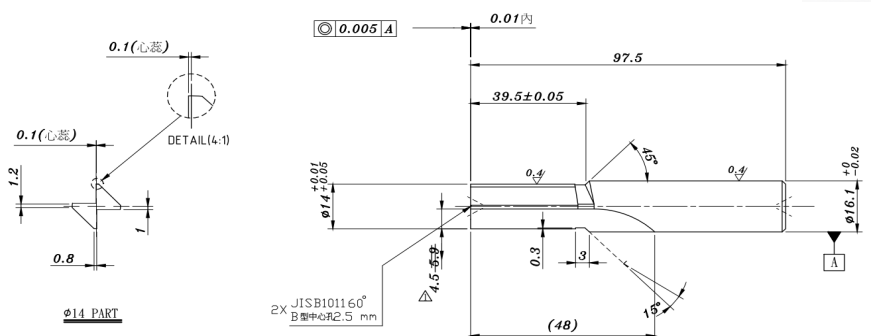













Stepreamer Ø14-Ø16

A15-200

This tool is basically not a finished tool, it is the shank before soldering of PKD inserts. The OD grinding was done before on a cylindrical grinding machine.



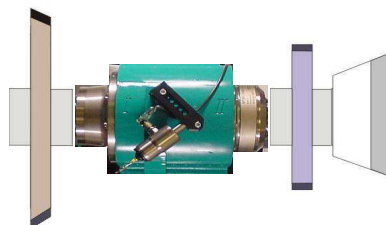
1. Cycletime for Production

Workpiece: end-Ø14, shank-Ø16.1 mm, Z 2, Length 48 mm, Helix angle 0° Material CARBIDE						
Operations	 Probe	 Flute 1	 Flute 2	 O.D.2	 O.D.1	 Special Step
Feed [mm/Min]	2000	30	200	30	60	60
Power [kW]		2	1	1	1	1
Cutting speed [m/s]		20	20	22	22	22
Used wheels		 1	 1	 2	 3	 3
Grinding time [s]	9	217	37	159	85	377
Total cycle time	14 Min 43					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø100 D76
2	11V9 Ø100 D76
3	1V1 Ø125 D76



3

1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP, 28.2.13

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

TECHNOLOGY FOR TOOLING